

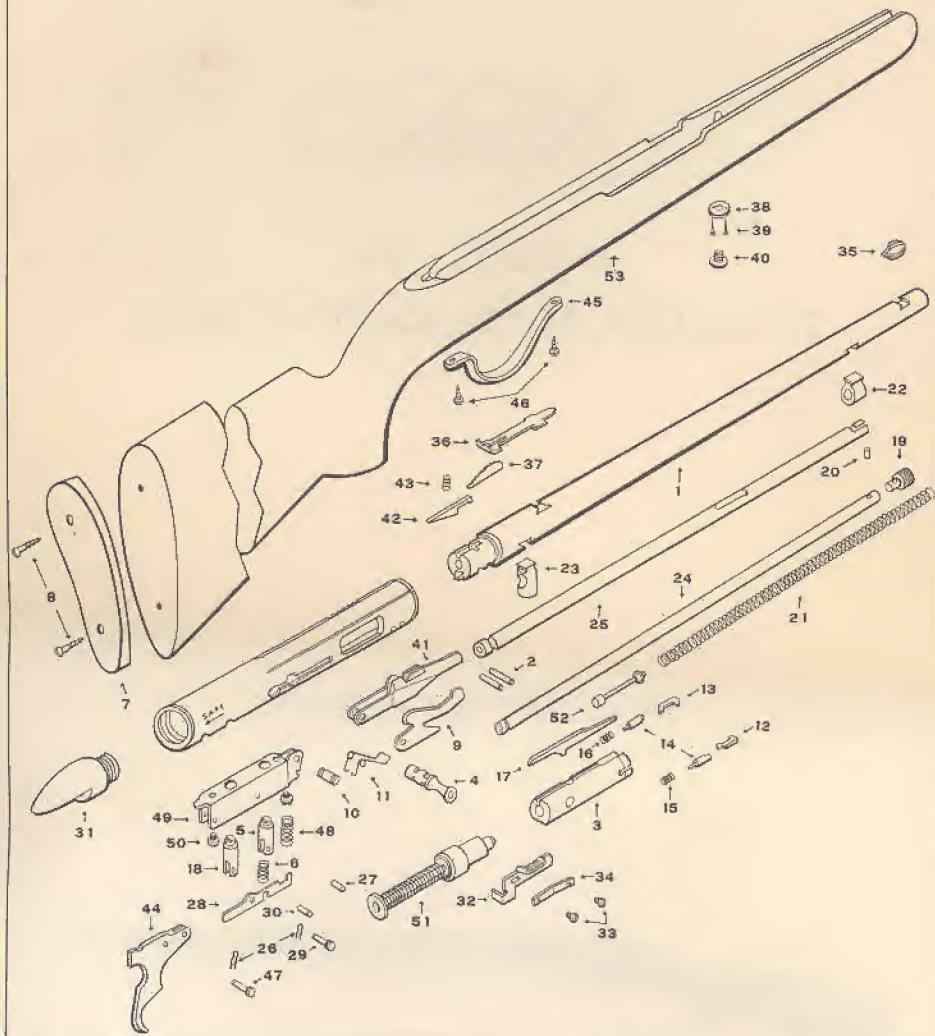
Sears

MODEL 25  
.22 CALIBER AUTO-LOADING RIFLE

LIST of PARTS and ASSEMBLIES



Sears Guns are sold ONLY by Sears, Roebuck and Co.  
and Simpsons-Sears Limited



## SPECIFICATIONS

Length of Pull	13 3/4
Drop at Heel	2 9/16
Drop at Comb	1 9/16
Barrel Length	22 1/4
Overall Length	42 3/4
Weight of Gun	5 lbs. - 10 oz.
Magazine Capacity	— 15 Long Rifle, 17 Longs, or 21 Shorts (Hi-Speed only)
Front Sight	— Post Type
Rear Sight	— Rocky Mountain partridge type with serrated blade for eleva- tion at 25 yard intervals.
Stock	— Walnut Finish

PARTS LIST FOR  
SEARS AUTO LOADING RIFLE  
MODEL NO. 583.2501

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION AS SHOWN IN THIS LIST:

- |                     |                      |
|---------------------|----------------------|
| 1. THE PART NUMBER. | 3. THE MODEL NUMBER. |
| 2. THE PART NAME.   | 4. THE NAME OF ITEM. |

All parts identified with a dagger (†) must be fitted to the gun by gunsmiths in Sears gunshops, or by qualified gunsmiths. Do not order repair parts by key number, always use the part number.

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	25000	†Barrel	30	25430	Plunger Connector Stop Pin
2	25010	†Barrel Pins (2)	31	25240	Receiver Plug, Rear
3	25030	†Bolt	32	25420	†Safety
4	25022	Bolt Handle	33	11430	†Safety Screw (2)
5	25060	Bolt Plunger	34	11435	†Safety Spring
6	25071	Bolt Plunger Spring	35	25621	Sight, Front
7	344	Butt Plate	36	478	Sight, Rear
8	345	Butt Plate Screws (2)	37	479	Sight Elevator, Rear
9	25170	Cartridge Lifter	38	11500	Takedown Escutcheon
10	25181	Cartridge Lifter Pin	39	11505	Takedown Escutcheon Pins (2)
11	25211	Cartridge Lifter Spring	40	11510	Takedown Screw
12	25271	Extractor, R. H.	41	25220	Throat
13	25281	Extractor, L. H.	42	25485	Top Ramp
14	25295	Extractor Plunger (2)	43	25490	Top Ramp Spring
15	25290	Extractor Spring, R. H.	44	25521	Trigger
16	25293	Extractor Spring, L. H.	45	11530	Trigger Guard
17	25300	†Firing Pin	46	11535	Trigger Guard Screws (2)
18	25231	Hammer Plunger	47	25510	Trigger Pin
19	25331	Magazine Cap	48	25515	Trigger Return Spring
20	328	Magazine Cap Pin	49	25405	†Underbody
21	4040	Magazine Spring	50	25410	†Underbody Screws (2)
22	25350	Magazine Support, Front		25830	†Bolt Assembly
23	25355	Magazine Support, Rear	51	25840	Hammer Assembly
24	25380	Magazine Tube, Inner	52	25860	Magazine Follower Assy.
25	25385	Magazine Tube, Outer	53	25871	Stock Assembly
26	11580	Pin Retaining Springs (3)	N.I.	25867	Magazine Tube Assembly
27	25430	Plunger Assembly Pin	N.I.	25510	Trigger Stop Pin
28	25440	Plunger Connector	N.I.	10675	Hammer Plunger Spr.
29	25510	Plunger Connector Pin			

N.I. Not Illustrated.

## MODEL 25

Look at the features built into this low priced semi-automatic rifle. It's easy to carry and fast handling for field shooting and plinking, with plenty of accuracy for target shooting too. As fast as you can pull the trigger, it will fire 15 L. R., 17 Long, or 21 Hi-Speed Shorts without any adjustment. The unique loading-port position permits rapid loading of magazine. The many custom features of this autoloading rifle have made it America's favorite among all .22 caliber rifles.

### DISASSEMBLE

To remove action from stock turn gun upside down and loosen takedown screw until action is free from stock.

To remove bolt and hammer assembly, unscrew rear receiver plug from receiver. Pull bolt handle fully rearward and remove bolt handle. Remove hammer assembly from receiver, and with gun held in vertical position pull trigger rearward thus allowing bolt assembly to fall free from receiver.

### IMPORTANT:

Before firing this rifle, be sure to clean barrel thoroughly of grease, or any obstruction.

## CLEANING & LUBRICATING

The performance of any semi-automatic rifle depends on how clean it is kept. Exclusive use of Sears' ammunition will keep fouling to a minimum, but, because a semi-automatic rifle depends on the powder gases for the repeating action, it must be kept clean to function efficiently. We recommend that your gun be thoroughly cleaned after firing approximately 200 to 250 rounds for continued top performance.

Using a large round brass wire brush soaked in solvent, clean inside of receiver, removing all residue. Clean bolt and hammer assemblies getting powder residue out of extractors, off face of bolt and firing pin, and out of machined cuts in bolt. Soak magazine throats in solvent and push a brass brush with solvent through feed ramp several times removing powder residue.

Pull a patch, moistened with a good solvent through the barrel from the breech end. Pull a brass brush, soaked in solvent through the entire length of the bore several times, using long even strokes. Pull clean patches through the bore in the same manner until the last patch comes out unsoiled. Push lightly oiled patch through the entire length of the bore.

Wipe all component parts dry, oil lightly and replace, following assembly instructions.

### ASSEMBLE

#### Bolt and Hammer Assembly

With gun on its side replace bolt by pulling trigger rearward and pushing bolt forward in receiver until bolt handle hole on side of bolt is in line with hole in receiver. Replace bolt handle and move bolt assembly fully forward. With trigger pulled rearward replace hammer assembly in receiver. Insert rear receiver plug and screw down until plug hits bottom, then back-off on plug until flat on plug is in line with flat portion of stock. Insert action in stock and tighten takedown screw until action is bedded in stock.

## OPERATING INSTRUCTIONS

**TO MAKE GUN SAFE:** Thumb safety is located at top, rear of stock next to receiver, on right of gun. With hammer cocked, draw safety rearward under thumb of right hand. This movement locks trigger, and rifle cannot be fired. Always LOCK gun when carrying it, loaded.

**TO RELEASE SAFETY:** Push safety fully forward and gun is ready to be fired.

**TO LOAD MAGAZINE:** With safety on, turn knurled knob on inner magazine tube, pull tube out and insert cartridges into cartridge opening, continuing the operation until last cartridge is visible. Grasping knurled portion of inside magazine tube, press down with rotating action until magazine tube is fully down and located in supporting notch.

**TO LOAD CHAMBER:** Retract action fully to the rear and allow to close. Push safety fully forward. Gun is now ready to fire.

**TO REMOVE CARTRIDGES; WITHOUT FIRING:** Put safety on (rearward). Remove inside magazine tube, and by pointing gun muzzle downward, all cartridges in the magazine tube will drop into the hand. Replace inside magazine tube and work action two or three times removing cartridges from barrel chamber and magazine throat assembly. Pull bolt operating handle back and examine barrel chamber and magazine throat to make sure gun is now empty of cartridges.